

ELECTRODE STORGE/CONDITIONING AND EXPOSURE LIMITS

AWS TYPE/ ELECTRODE FLUX	HOLDING OVEN TEMPERATURE AFTER OPENING CONTAINER	AMBIENT EXPOSURE LIMIT MAXIMUM HOURS
E6010 E6011 E6012 E6013 E6020 E6030 E7014 E7024 E7027	Heated Storage Not Required – Keep Ambient Temperature Between 40 °F – 140 °F	Scrap any electrodes that become damp or wet.
E7018 E8018 E9018 E10018 E11018	300 °F \pm 50 °F Portable heaters producing less than 250 °F (will be considered as ambient storage)	4 Hours 2 Hours 1 Hour 0.5 Hour 0.5 Hour
E308-16 E309-15 E310-15 E316-15	Heated storage not required	Scrap any electrodes that become damp or wet.
Flux Core and Solid Wires	Heated storage not required	Unlimited – Scrap any flux cored wire that becomes wet or damp.
Granular Flux for Submerged Arc Welding	Min. 300 °F	1 Hour @ min. 300 °F prior to use. Scrap any flux that has become wet or damp.
Cast Iron Coated Electrodes	Heated storage not required	Scrap any electrodes that become damp or wet.
Special Coated Electrodes or Brazing Material	Manufacturer's recommendations or contact the LANL Welding Program Administrator	Manufacturer's recommendations or contact the LANL Welding Program Administrator